

Date: Monday, 23/06/2008 9:19:14 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 39999			Part Number	: D2596	
Estimate Number	: 10346			Drawing Number	: D2596 REV D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 23/06/2008		S.O. No.	:		
Prsht Rev.	: NC			Drawing Revision	: D	
First Issue	: / /		Type	: SKIDTUBES		
Previous Run	: 39769			Material	:	
Written By	:			Due Date	: 30/06/2008	
Checked & Approved By	<u>JLD 08.6.23</u>			Qty:	4	
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M			Um:	Each	
	Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -'I' Beam Web 4"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick; Qty Part Number Description Batch	
	1 D2500-3-100	Extrusion	 <i>B-33940</i>
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr	<i>AWM</i> <i>8-6-23</i>
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	 <i>AWM 8-6-23</i>
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	<i>X47</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>8-08/06/08 C74</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock: <i>L-G AWM 8-6-23 (4)</i> Location: <i>L-G</i>		
6.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>08/06/24 JJ</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>MF 08-06-23</i>

Dart Aerospace Ltd

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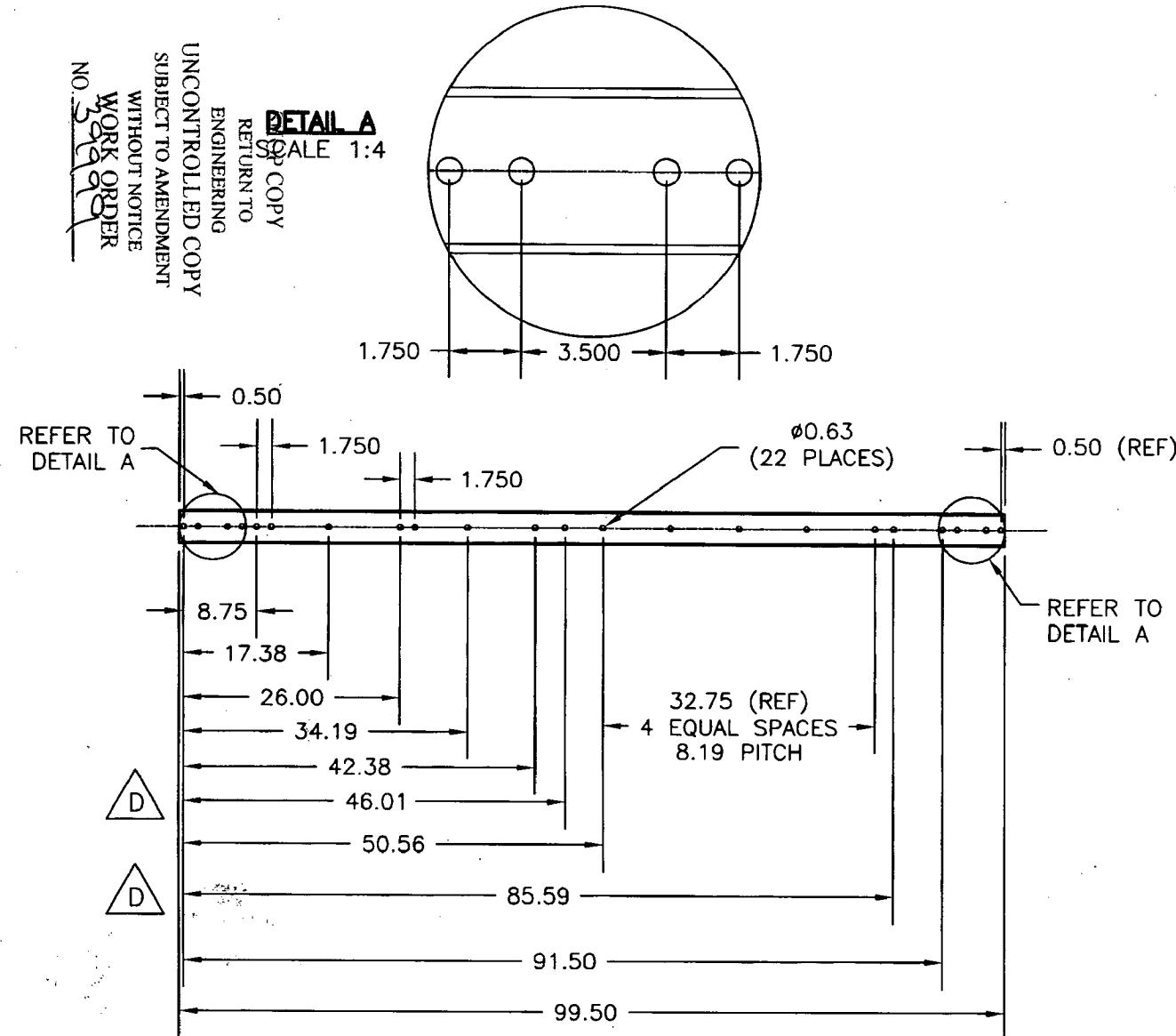
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DART AEROSPACE LTD
RH	RH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2596
DATE		TITLE
07.04.17		205 WEB
		SCALE
		1:20

RELEASED
R
07.04.18**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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